

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020757**Date Inspected:** 18-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhu Yuan Yuan.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Longitudinal Diaphragm

PCMK: SEG3019Z

Weld Number: 012

Welder: 066418

WPS-345-SMAW-2G-FCM-REPAIR

CWR 2755

Component: Anchor Plate

PCMK: SEG3019BB

Weld Number: 115

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Welder: 067610  
WPS-B-T-2114-FCM-1

Component: Longitudinal Diaphragm  
PCMK: SEG3019Z  
Weld Number: 014  
Welder: 067656  
WPS-345-SMAW-2G-FCM-REPAIR  
CWR 2755

Component: Longitudinal Diaphragm  
PCMK: SEG3019Z  
Weld Number: 008  
Welder: 037932  
WPS-B-P-2214-TC-U4b-FCM-1

Component: Side Plate I Rib  
PCMK: SEG3007L  
Weld Number: 062, 066  
Welder: 068924  
WPS-B-P-2213-B-U2-FCM-1

Component: Longitudinal Diaphragm  
PCMK: SEG3019AA  
Weld Number: 025  
Welder: 215553  
WPS-345-SMAW-2G-FCM-REPAIR

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Cable Tray Support  
PCMK: SA3190M  
Weld Number: 029, 030  
Welder: 062092  
WPS-B-P-2112

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Component: Cable Tray Support

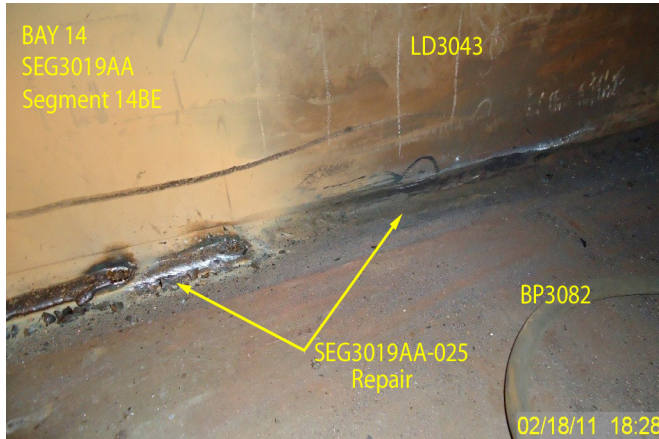
PCMK: SA3190L

Weld Number: 027, 028

Welder: 062092

WPS-B-P-2112

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

**Inspected By:** Combs,Dennis

Quality Assurance Inspector

**Reviewed By:** Riley,Ken

QA Reviewer